

Work Order ID 70911

Friday, June 17, 2011 7:42:49 AM



Page 1

Item ID: D3022-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 6/16/11

Tooling:

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3022

Rev B

FAI A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022

Dwg Rev: 8Prog Rev: A

*** grind direction along 31.700" ***

2-Deburr if necessary

B11-7-11

(3)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

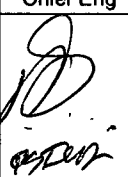
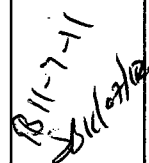

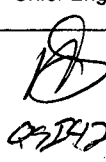
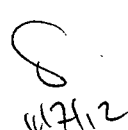
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Brake NC Brake NC	Bend as per dwg. NC BRAKE Memo 1- Bend as per Dwg D3022	0.00 0.00		SB 11/07/12					PTD
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 11/07/12					

W/O: 70911		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3022-1 PAR #: N/A Fault Category: Small PAB NCR: Yes No DQA: ✓ Date: 11/11/24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 11/11/24

NCR: 70911		WORK ORDER NON-CONFORMANCE (NCR) 33.01						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/07/24	130	Found 1 part with a defect on it R.C w/5 cut too close to end of sheet.		Scrap + Destroy no Rekey	 11-7-24	 11/07/24		 11/7/24

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Work Order ID 70911

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Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Transfer drill Seat Pan Front Frame ***Transfer drill in D3022-1 using D3017-041***								
	2-Debur								
160 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
170 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

N/A
Now done on
exxly
D350689-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

MT h

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: *W/A*

0.00

Memo

0.00

Q 11-11-23 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/23

11.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, June 17, 2011 7:42:56 AM

Page 1

Work Order ID: 70911

Parent Item: D3022-1

Parent Item Name: Seat Pan



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23 Revised NG
 IPP Rev:D 08-04-16 now water jet DD verified by:EC
 IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	24.4000	1.6232	1.708632			
2024-T3 .032 sheet													

S.

B11-7-11

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

118243

118243

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

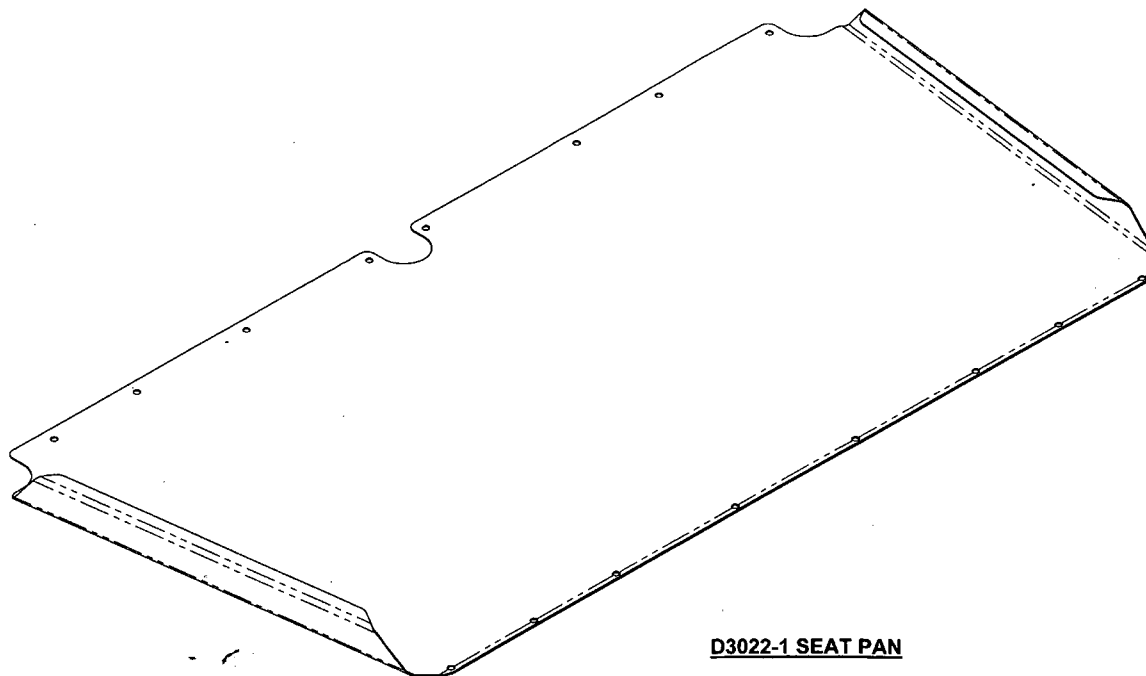
1

D

C

B

A

**D3022-1 SEAT PAN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70911
M11-06-17

RELEASED
08/12/15 M

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. 87-2 7" DIM ADDED. D7-3 12.075 WAS 12.325, D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 TITLE SEAT PAN SCALE NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		REV. B SHEET 1 OF 3		
DATE	08.11.27			

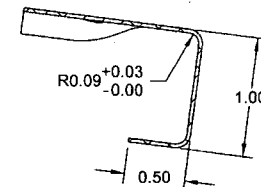
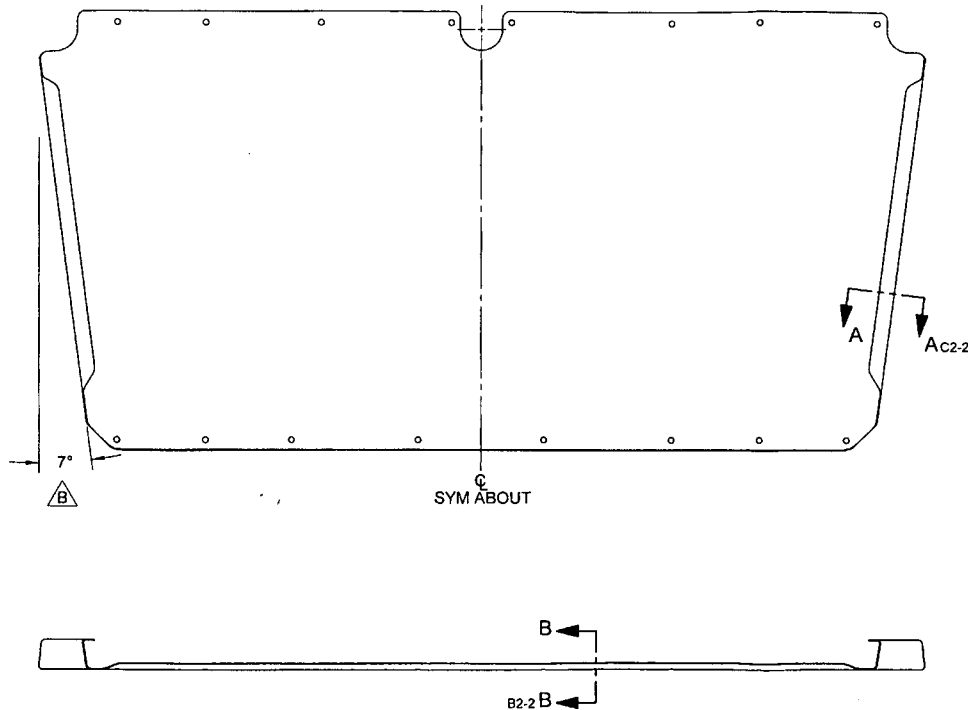
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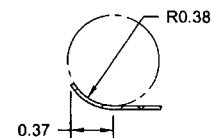
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SECTION A-A C4-2
SCALE 4X







SECTION B-B A6-2
SCALE 4X

D3022-1 SEAT PAN

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDETEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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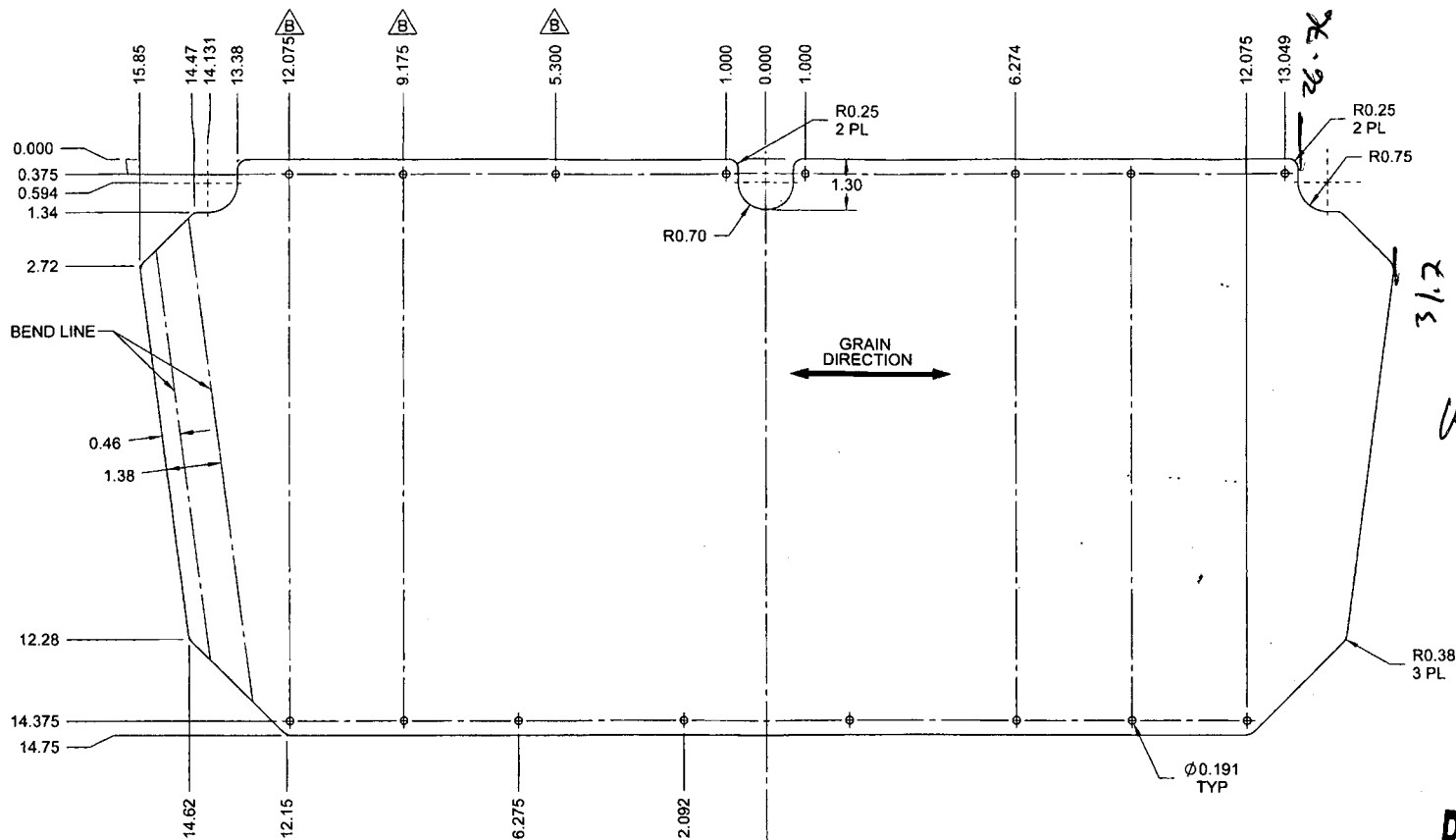
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

SYM ABOUT
UNLESS OTHERWISE
NOTED

RELEASED
08/12/15 JH

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
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